



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5445-042

Job Sheet 174734



Part No: D5445-042

Job Qty: 1 ea

Part Name: Longitudinal Beam Assembly, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/20/18

Job Tracking No:

Due Date: 4/20/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: D5445 REV C SHEETS 2,5 IPP REV:A 17.01.10 NEW ISSUE DD VERF:JLM IPP REV:B 17.11.15 REVISE AS PER INTUITIVE INSTRUCTION DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	1 Ea	4/20/18	4/20/18	0.00	0.00	Start Up Skid tubes-1		
100	CNC Bend Skid tubes	1 pcs	4/20/18	4/20/18	0.00	1.00	CNC Bend Skid tube		DAE 38
110	QC	1 pcs	4/20/18	4/20/18	0.00	0.00	QC2 GCS		9-89
120	Mill Conv	1 pcs	4/20/18	4/20/18	0.00	1.00	Mill Conv 1		
130	QC	1 pcs	4/20/18	4/20/18	0.00	0.00	QC2		18/5/11
140	QC	1 pcs	4/20/18	4/20/18	0.00	0.00	QC8		18/05/15
150	HandFinish	1 pcs	4/20/18	4/20/18	0.00	0.50	HandFinish1		18-05-16
160	QC	1 pcs	4/20/18	4/20/18	0.00	0.00	QC7		
170	Small Fab	1 pcs	4/20/18	4/20/18	0.00	1.00	Small Fab		DAE 38
180	QC	1 pcs	4/20/18	4/20/18	0.00	0.00	QC5		9-89
184	Skid tubes	1 pcs	4/20/18	4/20/18	0.00	0.50	Skid tubes-2		18-5-17
186	QC	1 pcs	4/20/18	4/20/18	0.00	0.00	QC5		18-5-17
190	Powdercoat	1 pcs	4/20/18	4/20/18	0.00	0.50	Powdercoat1		18-05-18
200	QC	1 pcs	4/20/18	4/20/18	0.00	0.00	QC3		18-05-18
210	HandFinish	1 pcs	4/20/18	4/20/18	0.00	0.50	HandFinish4		18-05-18
220	QC	1 pcs	4/20/18	4/20/18	0.00	0.00	QC5		18-05-18
230	Packaging	1 pcs	4/20/18	4/20/18	0.00	0.00	Packaging3		MAY 18 2018
240	QC21-SA	1 Ea	4/20/18	4/20/18	0.00	0.00	QC21		18-05-18

Part Op 100 - BEND/CUT AS PER DWG

Descriptions: 120 - MILL/DRILL AS PER DWG. -insure proper orientation -DEBURR

170 - INSTALL NUT PLATES AS PER DWG

184 - 1- Pick (4) D4720-1 space for each beams and chemical convert them. 2- Swage x-bolt spacers as per dwg. Trim off excess material as required. 3- After swaging, ream x-spacer hole if necessary to finish size. 4- Touch up alodine after swaging. 5-INSTALL END CAP

190 - ***MASK NUT PLATE HOLES*** START TIME: 1:46 OVEN TEMPERATURE: 320° FINISH TIME:

2:10

210 - SEAL END CAPS WITH SIKAFLEX AS PER NOTE 11



Container No: S064197



Part: D5445-042

Job No: 174734

Serial No/Batch: S064197

Revision: C

Inspector:

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CANADA
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Date: 04/23/18

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6TR1.5X1.0W125	6061-T6 Rect Tube 1.5 X 1.0 X .125W	6 ft (6 ea)	90-Start up Operation	M137953
CR2672-3-(03)	Cherry Rivet	8 Ea (8 ea)	170-Small Fab	5057521
MS21059-4	Nut Plate	3 Ea (3 ea)	170-Small Fab	5065256
MS21061L4	Nutplate	1 Ea (1 ea)	170-Small Fab	5065257
D4720-1	Spacer	4 Ea (4 ea)	184-Skidtubes	5030687
D5445-043	End Cap Assembly	2 Ea (2 ea)	184-Skidtubes	F158775
MS24694-S3	Screw	4 Ea (4 ea)	184-Skidtubes	M136643

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6TR1.5X1.0W125	6	48	0
170-Small Fab	CR2672-3-(03)	8	11	0
	MS21059-4	3	8	0
	MS21061L4	1	4	0
184-Skidtubes	D4720-1	4	402	0
	D5445-043	2	30	0
	MS24694-S3	4	59	0

Part Specifications

Specifications could not be found.

Plex 3/20/18 3:32 PM Dart.Gagnon.Michelle

DART AEROSPACE LTD	Work Order: 174734 75969
Description: Longitudinal Beam assy - RH	Part Number: 05445-2
Inspection Dwg: Same as P/N Rev: C	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
62.8"	$\pm 0.12"$	62.80	✓		Tape	
1.00 Ref	± 0.030	0.997	✓		Vernier CLK-19	
1.50 "	$\pm "$	1.496	✓		"	
0.13 "	$\pm "$	0.118	✓		"	
all 0.60 2 places	± 0.030	0.600	✓		"	
all 0.177	$\pm 0.002/-0.001$	0.178	✓		"	
all CSK 0.320 x 100°	"	0.320	✓		"	CSK 100°
0.85	± 0.030	0.850	✓		Vernier CLK-19	
1.200	± 0.010	1.200	✓		"	
0.500	"	0.500	✓		"	
0.50	± 0.030	0.500	✓		"	
54.63	$\pm "$	54.625	✓		Tape	
1.50	"	1.500	✓		Vernier CLK-19	
0.600	± 0.010	0.600	✓		"	
0.300	"	0.300	✓		"	
0.375"	$\pm 0.006/-0.001$	0.378	✓		"	
1.000	± 0.010	1.000	✓		"	
4.970	± 0.030	4.970	✓		"	
2.05	$\pm 0.12 / -0.05$	2.175	✓		"	
0.266	$\pm 0.006 / -0.001$	0.267	✓		"	
0.500	± 0.010	0.500	✓		"	
0.312	"	0.312	✓		"	
all 0.098"	$\pm 0.005 / -0.001$	0.099	✓		"	
all 0.179 x 100°	$\pm "$	0.180	✓		Vernier CLK-19	CSK
all 0.500	± 0.010	0.500	✓		Vernier CLK-19	
all 1.000	"	1.000	✓		"	
0.250	"	0.250	✓		"	
0.500	"	0.500	✓		"	

DAS
54
9-89

Measured by: [Signature]	Checked by: [Signature]	QC Inspector:
Date: 18/5/14	Date: 18/05/15	Date:

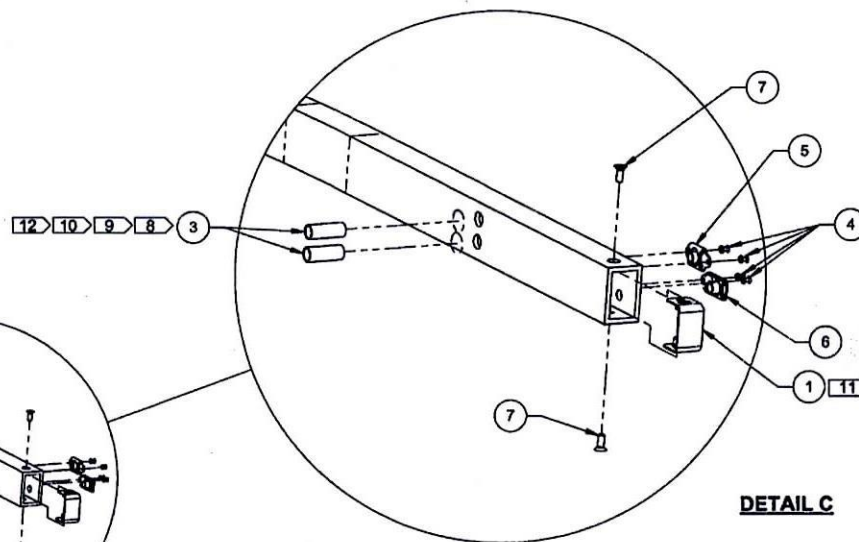
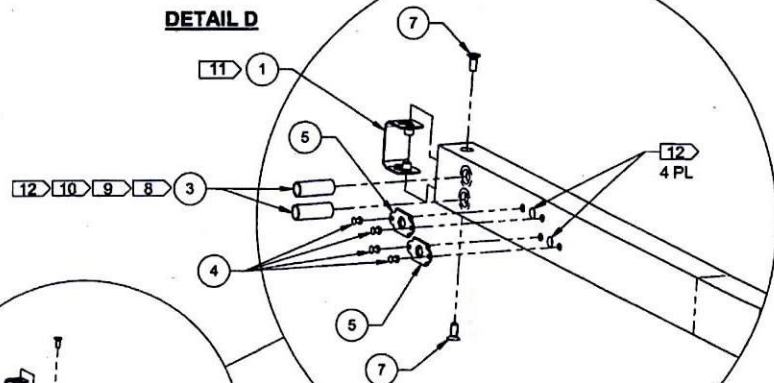
Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER *ms*
NO. 174734
MAR 21 2018

ITEM	QTY -042	P/N	DESCRIPTION
	X	D5445-042	LONGITUDINAL BEAM ASSEMBLY, RH
1	2	D5445-043	END CAP ASSEMBLY
2	1	D5445-2	LONGITUDINAL BEAM, RH
3	4	D5445-5	SPACER
4	8	CR2672-3-(03)	RIVET CHERRY, CSK
5	3	MS21059-4	NUT PLATE
6	1	MS21061L4	NUT PLATE
7	4	MS24694-S3	SCREW, CSK 100"
8	A/R	SIKAFLEX-241/-291	SEALANT

DETAIL D



DETAIL C

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.50 lbs
- 8) SWAGE TO $\phi 0.313$ THRU PER QSI 002 4.2
- 9) TRIM/GRIND FLUSH PER QSI 002
- 10) REAM THRU SPACERS USING $\phi 0.313$ REAMER
- 11) SEAL END CAPS WITH SIKAFLEX-241/-291
- 12) MASK HOLES PRIOR TO POWDER COAT

D5445-042 LONGITUDINAL BEAM ASSEMBLY, RH

RELEASED
2017-03-22

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	WK	DRAWING NO.	REV. C
MFG. APPR.	JLM	D5445	SHEET 2 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LONGITUDINAL BEAM ASSY	
DATE	17.02.09	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

